

Work Order ID 68489

Wednesday, August 03, 2011 8:31:09 AM



Page 1

Item ID: D2850-2

Accept



Setup Start



Revision ID:

Stop



Item Name: End Cap

Start Date: 4/14/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2850

Rev A

100

0.00



SHEAR

Shear

Memo

blanks: 3.8"

0.00

11/08/03

8

φ

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

Machine per Folio D2850-2
Deburr and Tumble

0.00

B.A 11/08/09

8

φ

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

B.A 11/08/09

8

φ

Quality Control

Work Order ID 68489



Page 2

Wednesday, August 03, 2011 8:31:09 AM

Item ID: D2850-2

Accept



Setup Start



Revision ID:

Stop



Item Name: End Cap

Start Date: 4/14/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC8- Inspect parts - second check

0.00 JL 11-08-10



QC Memo

0.00

Quality Control

8

140 Identify as per dwg & Stock Location WA

0.00



Packaging Memo

0.00

Packaging *** STOCK IN STEP CELL***

11/8/10 SP (80)

150 QC21- Final Inspection - Work Order Release

0.00



QC Memo

0.00

Quality Control

11/08/10

11-08-10 (8)

Picklist Print

Wednesday, August 03, 2011 8:31:06 AM

Page 1

Work Order ID: 68489



Parent Item: D2850-2



Parent Item Name: End Cap

Start Date: 4/14/2011

Required Date: 4/21/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP B 98.12.07 Changed folio DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X01.50 0		Purchased	No			110	f	36.0000	0.3208	2.701474			



6061-T6 Bar 2.50 x 1.50

Location

Loc Qty

Loc Code

MAT010

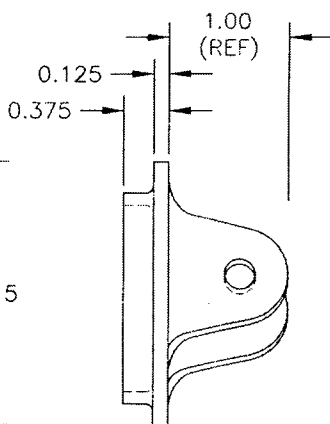
36

16742

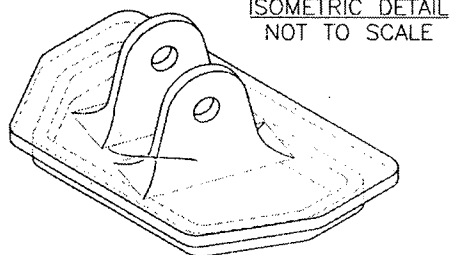
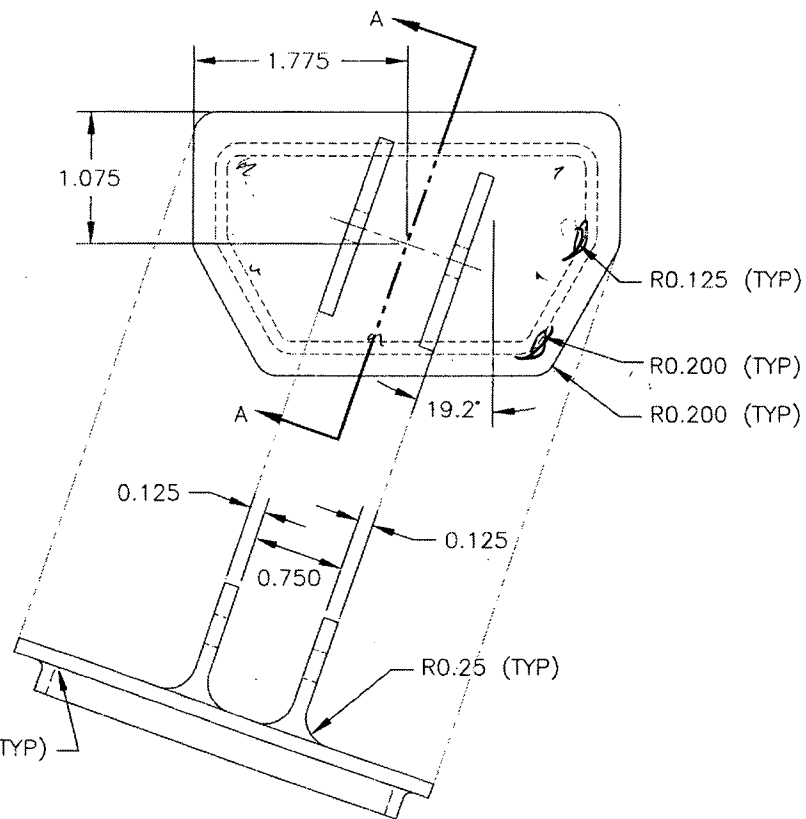
36

M107387 X 2.701

amt 1108/03

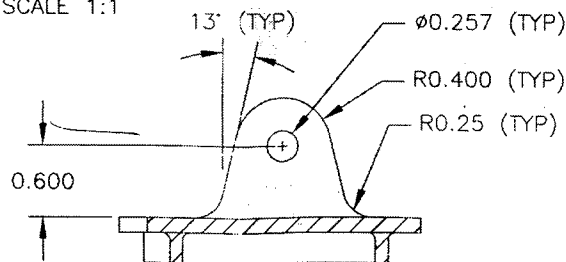


BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED



ISOMETRIC DETAIL
NOT TO SCALE




SECTION A-A
SCALE 1:1



W/068489

RELEASED
95/129 62



A	98.11.10		NEW ISSUE, REPLACES D2357 REV. A AND D2358 REV. B	
DESIGN	DRAWN BY		DART AEROSPACE LTD HARRISVILLE, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A	
		D42850	SHEET 1 OF 1	
DATE	TITLE		SCALE	
98.11.10	HIGH FLOAT STEP END BRACKET		1:1	

DART AEROSPACE LTD		Work Order: 68489
Description: High Float Step End Bracket		Part Number: D2850-2
Inspection Dwg: D2850	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.55	+/-0.030	3.552	✓		Vern	GA-01
0.189	+/-0.010	0.188	✓		HG	31006
1.720	+0.000/-0.030	1.720	✓		Vern	GA-01
0.178	+/-0.010	0.177	✓		"	"
0.10	+/-0.030	0.099	✓		"	
30°	+/-0.5°	30°	✓		Angle prot.	MLL-CBB
2.15	+/-0.030	2.152	✓		Vern	GA-01
0.375	+/-0.010	0.374	✓		"	"
0.125	+/-0.010	0.124	✓		"	"
1.00	+/-0.030	1.000	✓		H-6	31006
0.125	+/-0.010	0.128	✓		Vern	GA-01
0.750	+/-0.010	0.752	✓		"	"
R0.25	+/-0.030	R0.250	✓		R-6	ref.
R0.063	+/-0.010	R0.063	✓		"	"
Ø0.257	+0.006/-0.001	Ø0.259	✓		Vern	GA-01
0.600	+/-0.010	0.598	✓		H-6	31006

Measured by: H.A	Audited by: SL	Prototype Approval:	N/A
Date: 11/08/09	Date: 11-08-10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	

1915. 1. 15

1915. 1. 15